

Date: Friday, 2/23/2007 8:31:58 AM  
 User: Tim Johnston

## Process Sheet

*SPLIT* *4*

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 30890 *EB*  
 Estimate Number : 10351  
 P.O. Number : *N/A*  
 This Issue : 2/23/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : MACHINED PARTS  
 Previous Run : 24407  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]* 07.02.23  
 Comment : Est: A 01.07.11 New Issue: SM/EC

Drawing Name : CLAMP  
 Part Number : D30413  
 Drawing Number : D3041 UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision : UNDER REVIEW *C*  
 Material : *N/A*  
 Due Date : 3/10/2007 Qty: *45* *43*  
*etc*

Qty: *20* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0

D2423

Lug Extrusion



*4.923*



Comment: Qty.: 0.1094 f(s)/Unit Total: 2.1882 f(s)

Lug Extrusion  
(D2423)

Batch: *33062*

*En 07/03/12*

*45*

2.0

BAND SAW

BAND SAW



*2mm*



Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

*En 07/03/12*

*45*

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



*Issue to 3287*

*02/07/03*



*45*

Comment: HAAS CNC VERTICAL MACHINING #1

Check for cracks while loading into the machine

Machine as per Folio FA153 and Dwg D3041

Tumble and Deburr rough edges after tumbling

Identify as D3041-3

*machine per drawing  
D3041 Rev C*

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



*Receive + Inspect for*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*transit damage 04/04/02 45*

5.0

QC5

SECOND CHECK



*Issue to 3287*



Comment: SECOND CHECK

*Inspect Level 5 43*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 30890

Part Number: D30413

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(43x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/04/09

7.0

POWDER COATING

POWDER COATING



M103706

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

FEL

07/04/10 (43)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(43x)

Comment: INSPECT POWDER COAT

M-L

07/04/10

(PT)

9.0

D2611

Bearing



Comment: Qty: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bearing

Pick:

Qty	Part Number	Description	Batch
1	D2611	Bearing	33190

33190

SB 07/04/17 (1)

10.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

SB 07/04/17 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/18 (1)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

E 07/04/18 (1)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 30890

Part Number: D30413

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107104/19

Job Completion:



107104/19





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

43

D3041-3

Lug B30890

3287

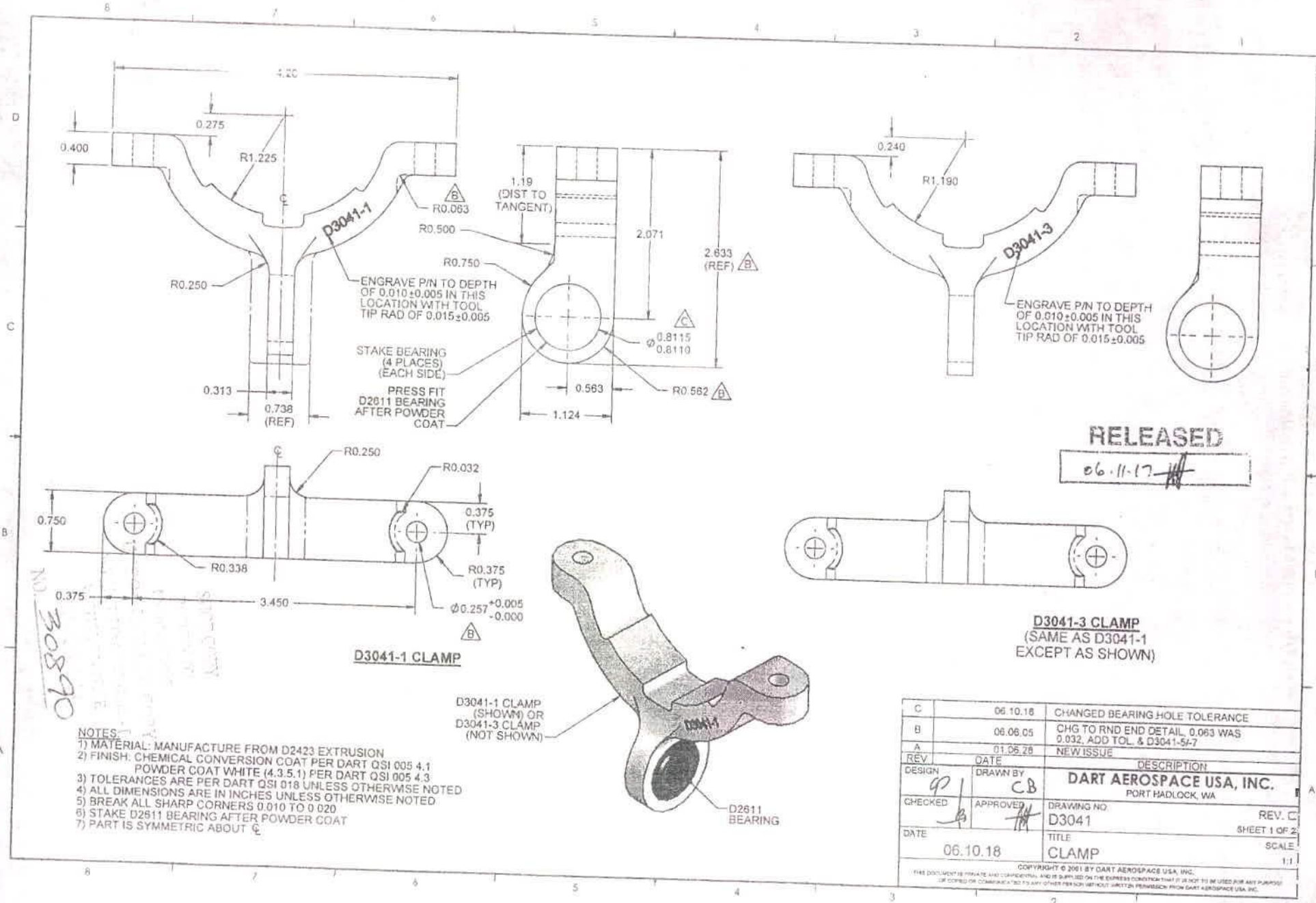
MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Denise Robinson

Vankleek Hill, April 2, 2007



C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL 0.063 WAS 0.032, ADD TOL. & D3041-5-7
A	01.05.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	<b>DART AEROSPACE USA, INC.</b>
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	06.10.18	DRAWING NO. <b>D3041</b>
		TITLE <b>CLAMP</b>
		REV. C SHEET 1 OF 2
		SCALE 1:1

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